

Date: Tuesday, 07/04/2009 3:19:04 PM
 User: Melanie Fauteux

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : HANDLE AND LOCK- DOWN ASSY |
| Job Number | : 47047 | | |
| Estimate Number | : 13526 | | |
| P.O. Number | : | Part Number | : D3451045 |
| This Issue | : 07/04/2009 S.O. No. : | Drawing Number | : D3451 REVA |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 07/04/2009 Type : LARGE FAB ASSY | Drawing Revision | : A |
| Previous Run | : 45309 | Material | : |
| Written By | : | Due Date | : 14/04/2009 Qty: 1 Um: Each |
| Checked & Approved By | : <u>mf 09-04-08</u> | | |
| Comment | : Est Rev:A 08-06-27 new issue DD verified by:ec | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|------------------------------|
| 1.0 | D34515 | Tube Handle Arm |
| ✓ | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Tube Handle Arm batch: <u>B41461 = 2x</u> <u>SP 09.04.16</u> | | |
| 2.0 | PB6743001103 | Tube Handle |
| ✓ | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Tube Handle batch: <u>B47086 = 1x</u> <u>SP 09.04.16</u> | | |
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
| | | |
| Comment: LARGE FABRICATION RESOURCE 1 1- weld as per dwg PB67-43001 <u>SP 09.04.16</u> (1x) | | |
| 4.0 | QC9 | VISUAL WELDING INSPECTION |
| | | |
| Comment: VISUAL WELDING INSPECTION <u>PD 09.04.17</u> (1) | | |
| 5.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| | | |
| Comment: INSPECT WORK TO CURRENT STEP <u>SP 09.04.17</u> (1) | | |
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| | | |
| Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>SP 09-04-12</u> (46) | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:19:04 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE AND LOCK- DOWN ASSY

Job Number: 47047

Part Number: D3451045

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M18144



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 8:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00am

JH 05-04-17

(X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 02/04/17 (1)

9.0

GP211

Rubber Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rubber Handle

batch: M109004✓

LPC 09.04.20

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble rubber handle as per dwg PB67-43001

LPC 09.04.20

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/20 (1)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 440

9/4/20

(1x) 50

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 JH

Job Completion



MF 09-04-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

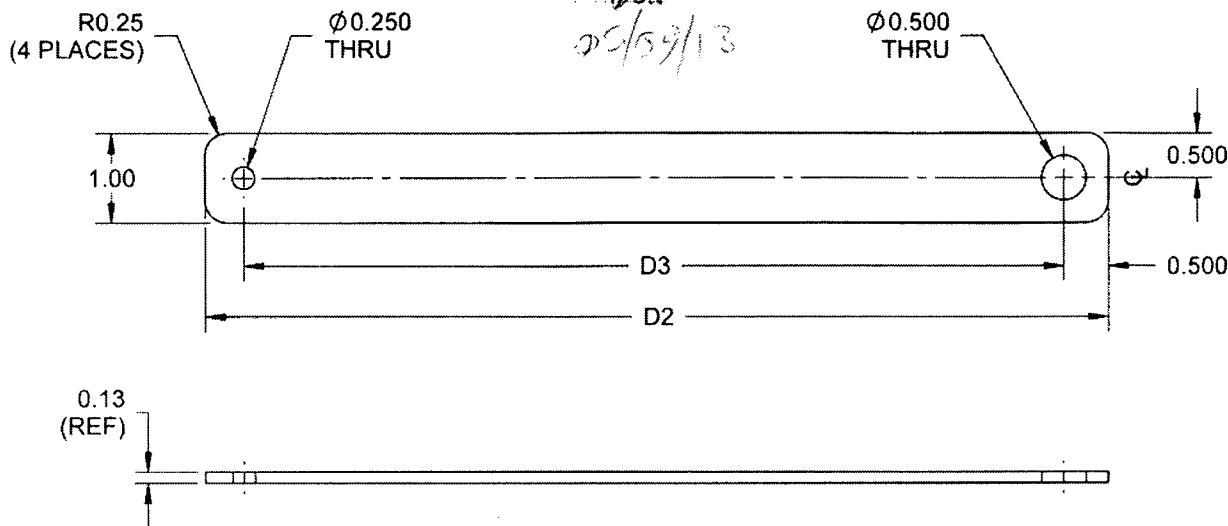
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3451 | REV. A SHEET 2 OF 2 |
| DATE 05.08.25 | | TITLE HANDLE & LOCK-DOWN ASS'Y SCALE 1:2 | |



| P/N | D2: CUT LENGHT | D3: HOLE SPACING |
|---------|----------------|------------------|
| D3451-1 | 10.25 | 9.200 |
| D3451-3 | 10.63 | 9.700 |
| D3451-5 | 8.00 | 7.100 |
| D3451-7 | 10.00 | 9.000 |

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303
D3451-5 SUPERSEDES PREMIER P/N B67-43001-301
D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

247047

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

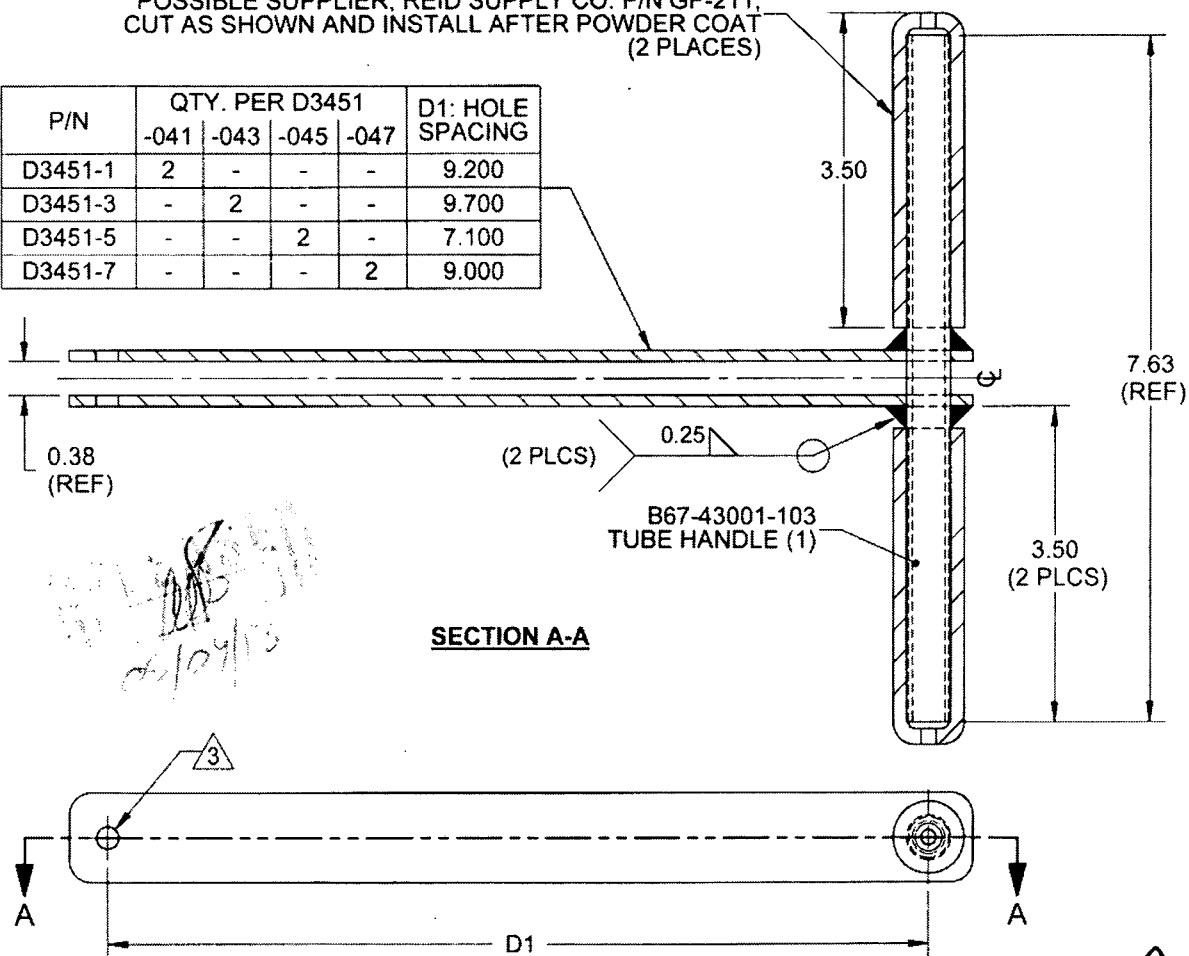
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



| | | | |
|-------------------------|----------|--|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3451 | REV. A SHEET 1 OF 2 |
| DATE 05.08.25 | | TITLE HANDLE & LOCK-DOWN ASS'Y | SCALE 1:2 |
| A | 05.08.25 | NEW ISSUE | |

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,
CUT AS SHOWN AND INSTALL AFTER POWDER COAT
(2 PLACES)

| P/N | QTY. PER D3451 | | | | D1: HOLE SPACING |
|---------|----------------|------|------|------|---------------------|
| | -041 | -043 | -045 | -047 | |
| D3451-1 | 2 | - | - | - | 9.200 |
| D3451-3 | - | 2 | - | - | 9.700 |
| D3451-5 | - | - | 2 | - | 7.100 |
| D3451-7 | - | - | - | 2 | 9.000 |



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41

D3451-045 SUPERSEDES PREMIER P/N B67-43001-39

D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.